

Work Order ID 75589

75589

Page 1

Wednesday, October 26, 2011 10:01:59 AM

Item ID: D412-742-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Float Skidtube

Start Date: 10/26/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/4/2011 Req'd Qty: 1.00

1

Customer:

Reference:

U/R

Approvals: Process Plan: *W*

Date: 11-10-26

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3391

H U R

Q 11.11.07

0.00

100

100

DOCUMENT CONTROL

0.00

DC

Document Control

Memo

If D412-742-043 is a W/O on it's own,
Photocopy bluefile and create labels per PPP D412-742-043 CHG004

using D3391 Ract
D519512

CHG 005 CHG 004 CHG 005
11.11.08

W/O: 75589		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11.11.15		USE D4095-041/-043 WEARSHOE'S PER DS1 9517 Rev.B	JS	11/12/01	X1 ASS	GP 11.11.15 DS1042	MH 11.12.02	
11.11.21		USE WEARSHOE/WEARPADS & D4095-041 (INSTEAD OF D3564-1), D4095-051 (INSTEAD OF D3564-13) D4095-043 (INSTEAD OF D3564-52), D4095-049 (" OF D3537-1) D4095-045 (INSTEAD OF D3564-5), D4095-047(" OF D3537-7) TUBE IS CHG 005	JS	11/12/01	X1 ASS	GP 11.11.21 DS1042	MH 11.12.02	

Part No: D412-742-043 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 75589		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75589

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Page 2

Wednesday, October 26, 2011 10:01:59 AM

Item ID: D412-742-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Float Skidtube
 Start Date: 10/26/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/4/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	HandFinishing	0.00				1	0	11/12/02	
110	HandFinish	0.00							
Hand Finishing	<div><div>Memo</div><div>1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins. ✓ A/RSikaflex-241/-291 <u>1119443</u> Expiry date: <u>12/01</u></div><div>2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex. ✓ A/RSikaflex-241/-291 <u>1119443</u> Expiry date: <u>12/01</u></div><div>3-Remove "T" pins once sikaflex is dry.</div><div>✓ 4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser. - A/RLPS Procyon <u>1114596</u></div></div>								

★ SEE W/D CHG ON BACK

★ SEE W/D
CHG ON BACK

W/O: 75589

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11.11.22	110	INSTALL WEAR PLATES ON SKID TUBE PER D3391 Rev.I, USING SHORTER BOLTS PER DWG	JA	12/01/12	x1	CP 11.11.22 Q51642	M/M 11.12.02

Part No: D412-742-043 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 3

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 Revision ID: Stop ***NS2***
 Item Name: Replacement Float Skidtube
 Start Date: 10/26/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/4/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00				W	11	12	02 (1)
Quality Control									
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-742-043								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

PPP 75593

11/12/08

11/12/05

MF 11-12-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 26, 2011 10:01:58 A

Page 1

Work Order ID: 75589
 Parent Item: D412-742-043
 Parent Item Name: Replacement Float Skidtube

Start Date: 10/26/2011 Required Date: 11/4/2011
 Start Qty: 1.00 Required Qty: 1.00

Comments: IPP Rev A05.10.13New Issue KJ/JLM
 IPP Rev B06.02.13ECN 773 dwg @ rev.D EC
 IPP Rev:C 07-05-28 As per Rev F JLM
 IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM
 IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN3C4A BOLT		Purchased	No			110	Each	2,547.0000	24	24			
----------------	--	-----------	----	--	--	-----	------	------------	----	----	--	--	--

Location	Loc Qty	Loc Code
ST350	2547	
117313	2	
117688	5	
117872	22	
118112	16	
118451	2	
118706	500	
118838	1000	
119328	1000	

AN3C6A BOLT		Purchased	No			110	Each	220.0000	12	12			
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Qty (8)

9/11/11.15

Location	Loc Qty	Loc Code
FP-A	1	
111982	1	
ST351	219	
111982	2	
116419	23	
116549	2	
116704	12	
117619	10	
117688	1	
117872	5	
118422	164	

x 8

W/O: 75589		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/2/01	110	Replace (x2) AN3CGA bolts for (2x) AN3C-5A bolts for better fit. As per instructions 11118451	WJ	11/2/01	(x2)	P 11/2/01 PS/UMR	WJ 11-12-02

Part No: D412-742-043 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, October 26, 2011 10:01:58 A

Work Order ID: 75589

Parent Item: D412-742-043

Start Date: 10/26/2011

Required Date: 11/4/2011

Parent Item Name: Replacement Float Skidtube

Start Qty: 1.00

Required Qty: 1.00

AN3C7A Purchased No

110 Each 147.0000

BOLT Qty (4)

~~8~~ 11/12/11

Location	Loc Qty	Loc Code
ST351	147	
113149	14	
116169	1	
117313	10	
117619	12	
117688	34	
118422	76	

AN960C10L Qty(38) NAS1149C0332R Purchased No

110 Each 0.0000

washer
D3391-021 ~~NA used on 3391-023~~
Fwd Tube Assembly

110 Each 0.0000

D3391-023 Manufactured No

110 Each 0.0000

Mid Tube Assembly

D3391-025 Manufactured No

110 Each 0.0000

Aft Tube Assembly

~~D3564-1~~ D4095-041 Manufactured No

110 Each 8.0000

Wearshoe

Location	Loc Qty	Loc Code
FG	2	
33798	2	
FP019	6	
72508	6	

~~D3564-3~~ D4095-043 Manufactured No

110 Each 14.0000

Wearshoe
Pr. 11.15

Location	Loc Qty	Loc Code
FG	2	
33764	2	
FP	9	
71656	9	
FP019	3	
64748	3	

Wednesday, October 26, 2011 10:01:58 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 3

Work Order ID: 75589

Parent Item: D412-742-043

Start Date: 10/26/2011

Required Date: 11/4/2011

Parent Item Name: Replacement Float Skidtube

Start Qty: 1.00

Required Qty: 1.00

~~D3564-5~~ D4095-045 Manufactured No 110 Each 16.0000 1
Wearshoe B76050 (x1) 11/11/23

Location Loc Qty Loc Code

FG 2

34806 2

FP19 14

73330 14

~~D3566-1~~ N/A Manufactured No 110 Each 45.0000 2
Gasket 11/11/15

Location Loc Qty Loc Code

FP002 43

73303 17

74518 26

FP015 2

68924 2

~~D3566-5~~ N/A Manufactured No 110 Each 36.0000 1
Gasket

Location Loc Qty Loc Code

FP002 34

74387 12

75069 22

FP015 2

72849 2

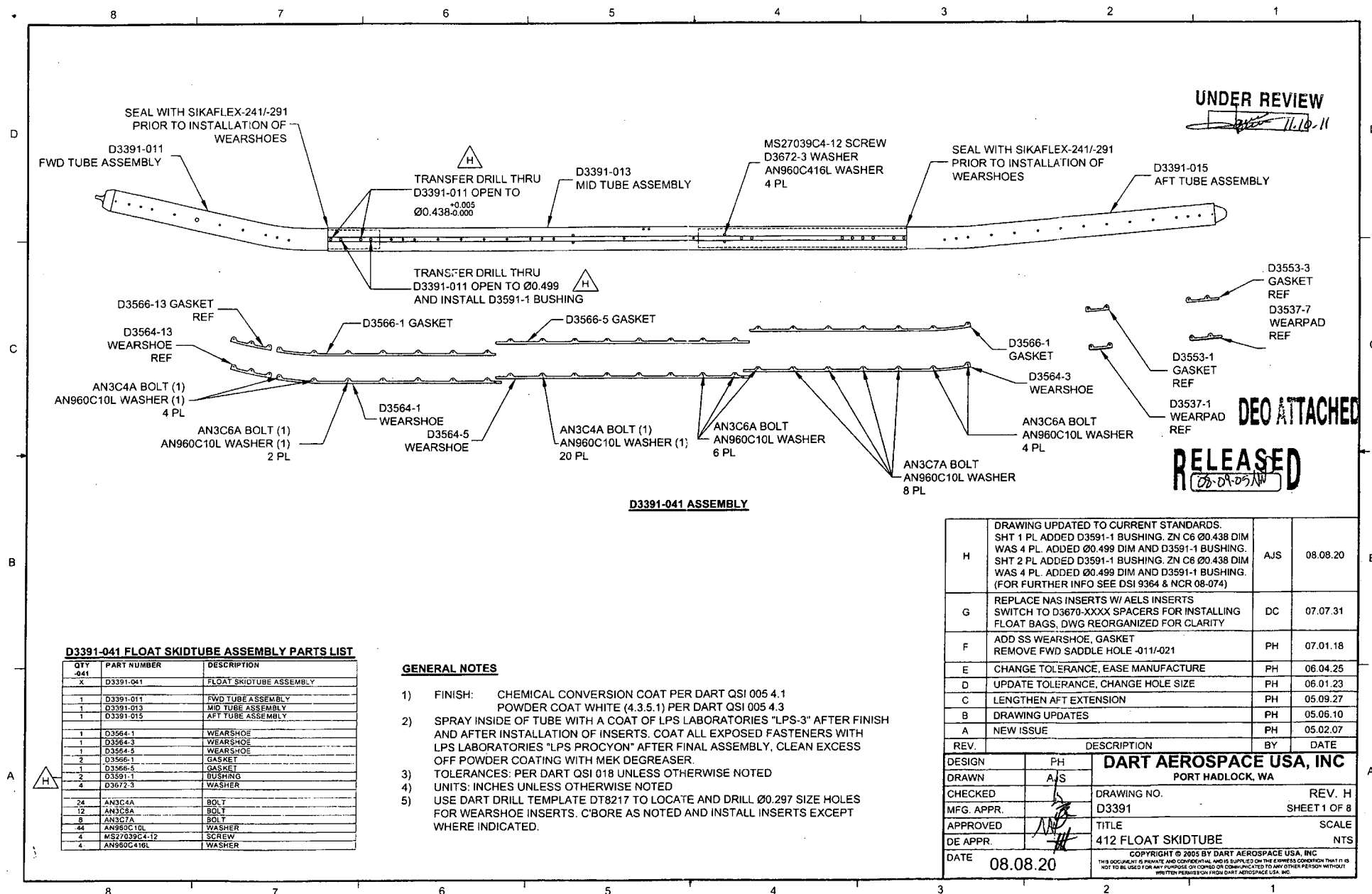
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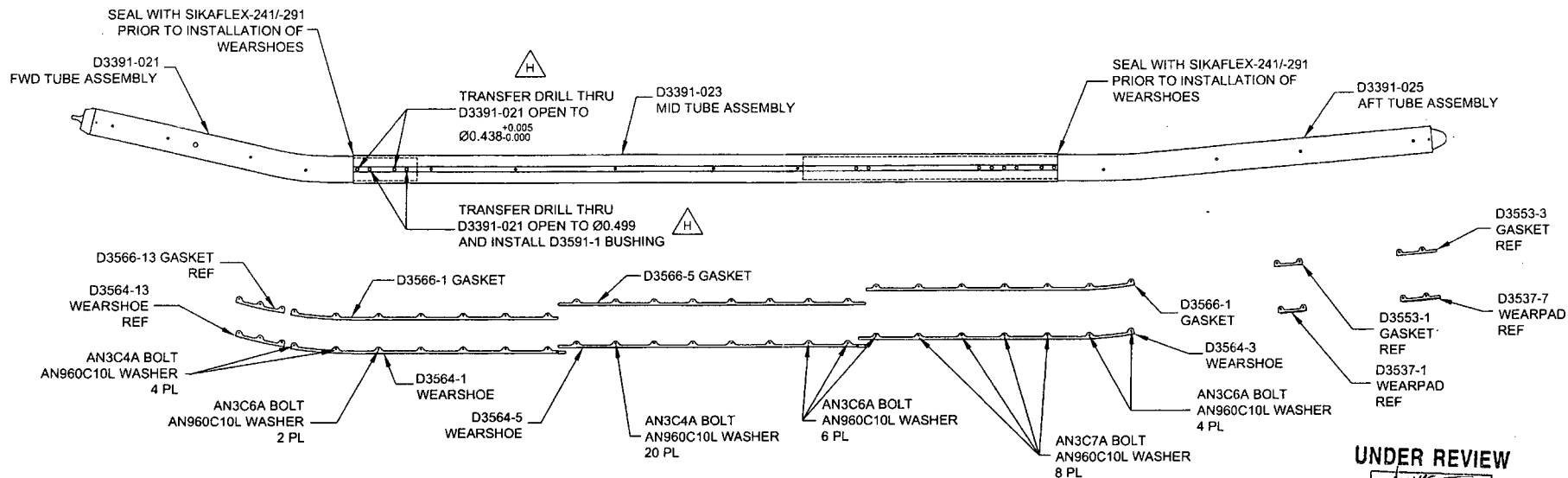
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D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. CBORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
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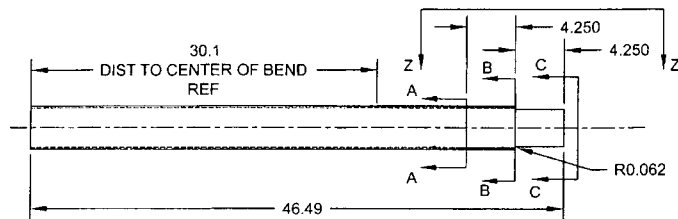
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

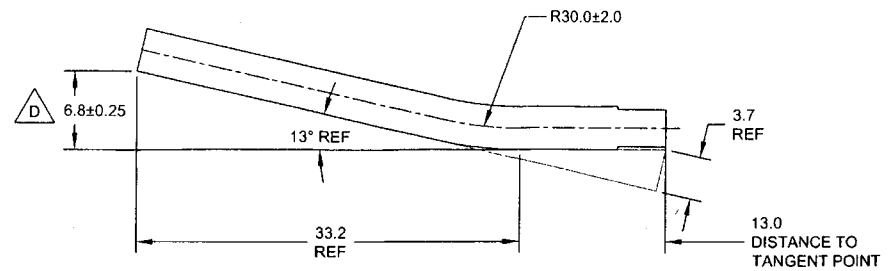
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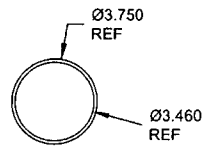
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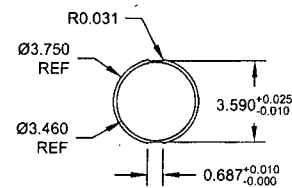
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



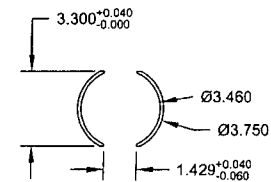
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



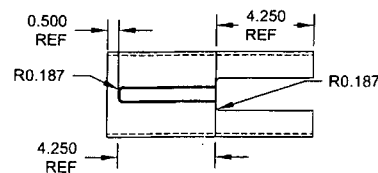
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

UNDER REVIEW
[Signature] 11-10-11

DEO ATTACHED
RELEASED
[Signature] 08-05-11

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D3391	SHEET 3 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	412 FLOAT SKIDTUBE	NTS
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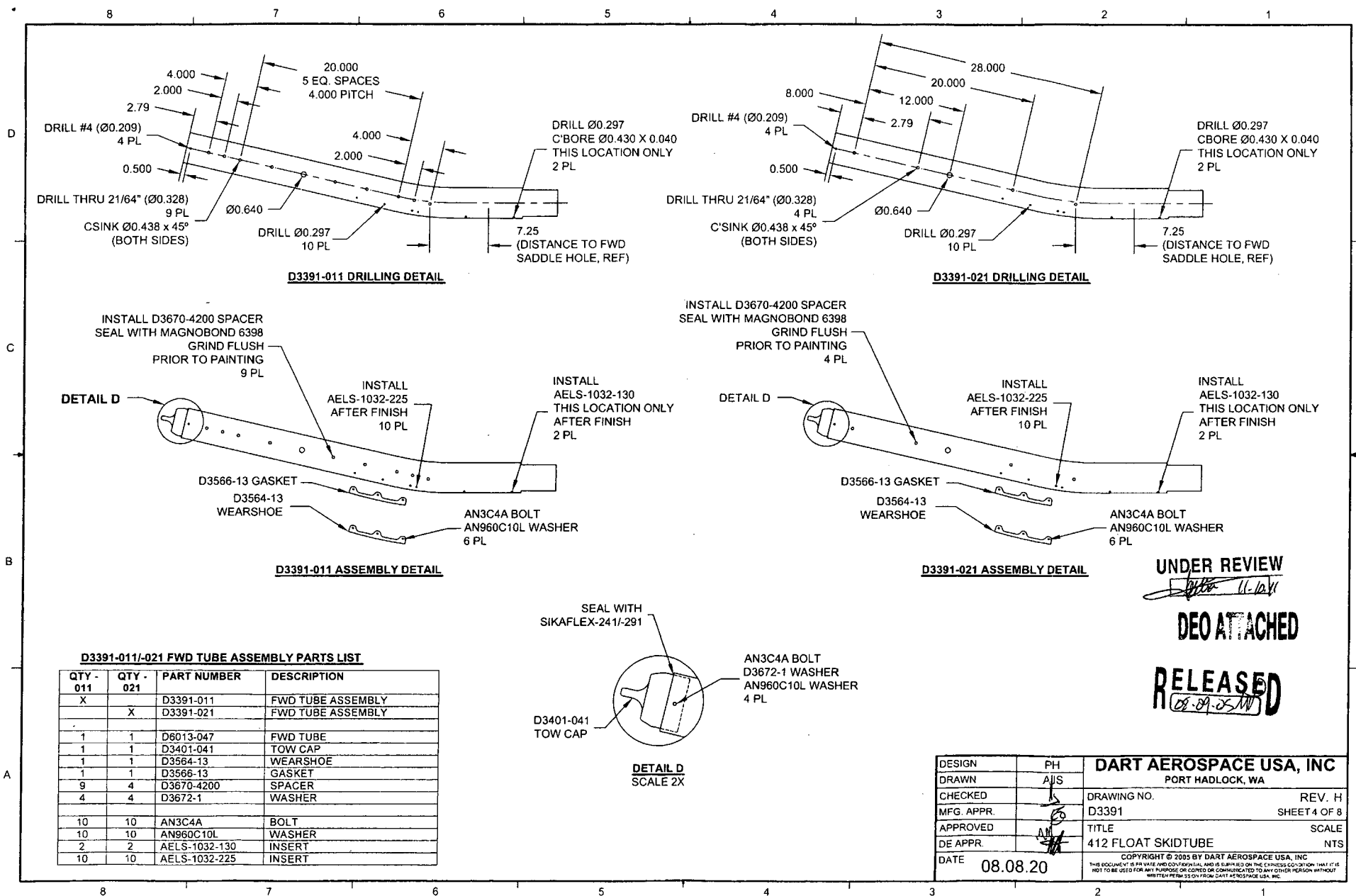
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


NOTE: Date & initial all entries



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CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 4 OF 8
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DE APPR.		412 FLOAT SKIDTUBE	NTS
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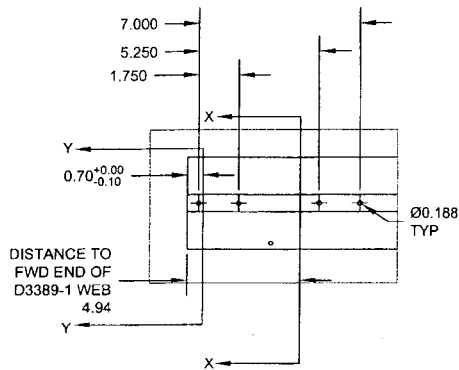
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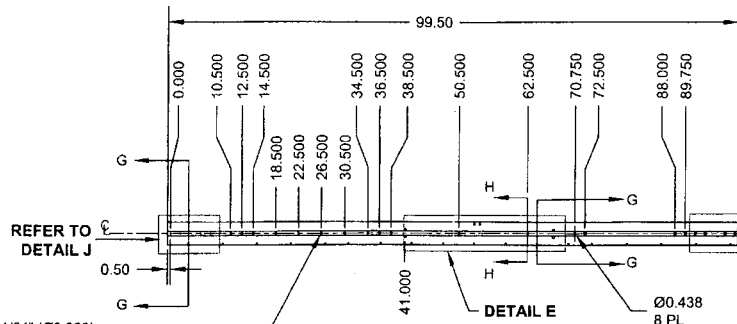
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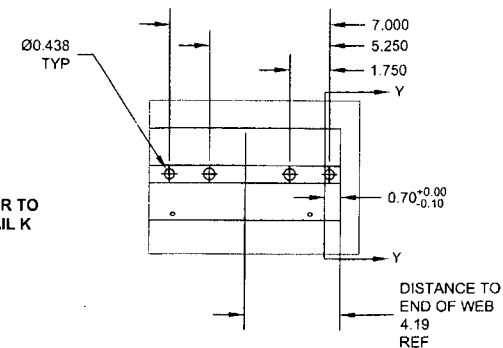


DETAIL J
SCALE 4X

DRILL THRU 21/64" (Ø0.328)
CSINK Ø0.438 X 45° (BOTH SIDES)
12 PL



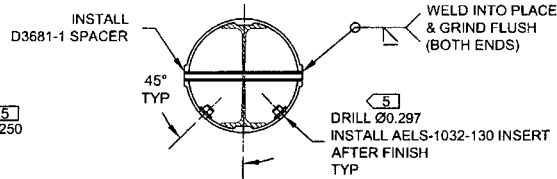
D3391-013 ASSEMBLY DETAIL



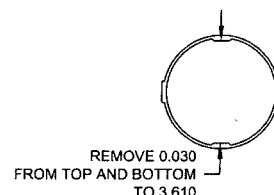
DETAIL K
SCALE 4X



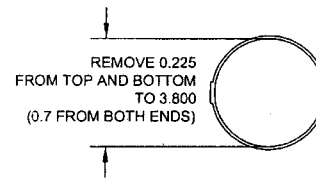
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SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



SECTION Y-Y
SCALE 5X

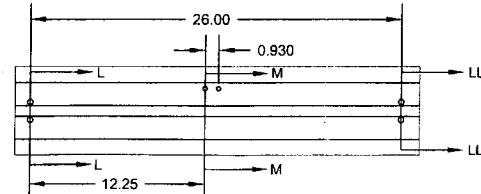
UNDER REVIEW
11/17/11

D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

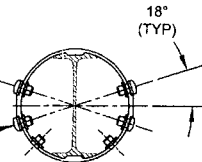
D3391-013 MID TUBE ASSEMBLY

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- WELDING: PER DART QSI 004

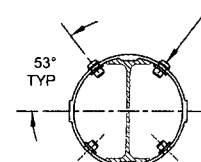


DETAIL E
SCALE NONE

DRILL Ø0.391
INSTALL ALS4-428-165 INSERT
MS27039C4-08 SCREW
D3672-3 WASHER
AN960C416L WASHER
AFTER FINISH
4 PL

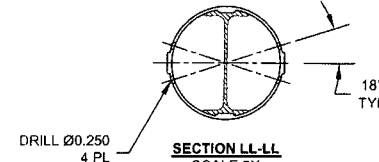


SECTION L-L
SCALE 5X



SECTION M-M
SCALE 5X

DRILL Ø0.297
INSTALL AELS-1032-130 INSERT
MS27039C1-09 SCREW
D3672-1 WASHER
AN960C10L WASHER
AFTER FINISH
4 PL



SECTION LL-LL
SCALE 5X

DEO ATTACHED

RELEASED

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AUS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 5 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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8 7 6 5 4 3 2 1

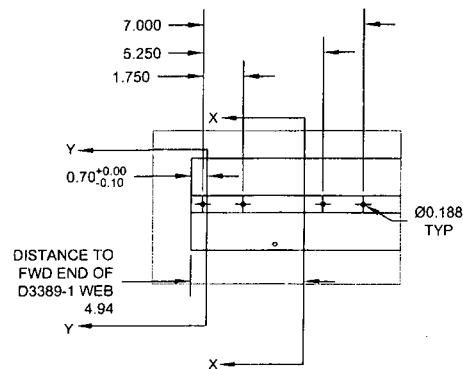
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

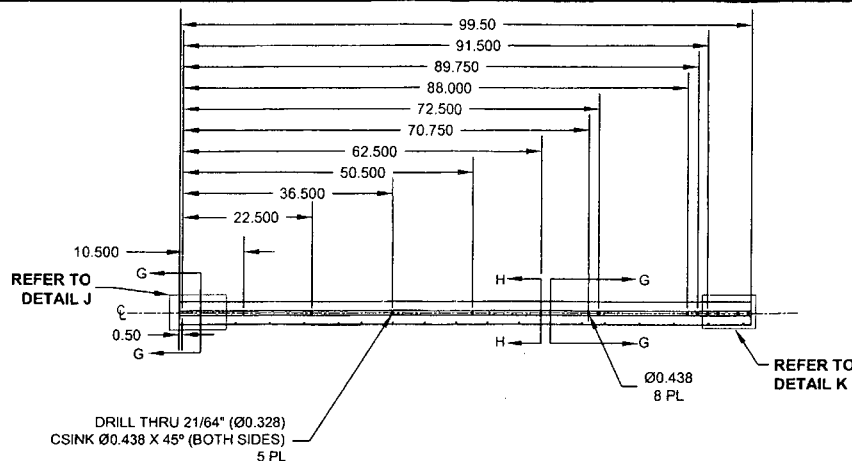
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

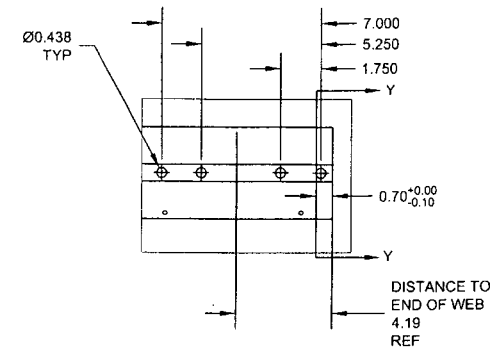
NOTE: Date & initial all entries



DETAIL J
SCALE 4X



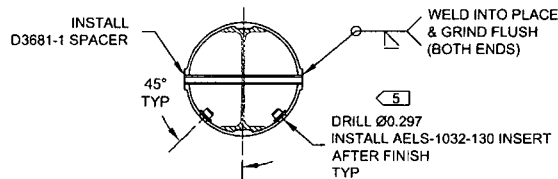
D3391-023 ASSEMBLY DETAIL



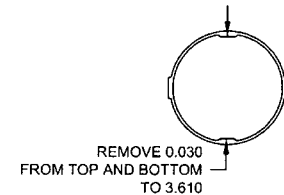
DETAIL K
SCALE 4X



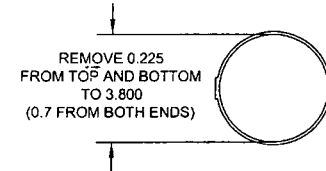
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY -	PART NUMBER	DESCRIPTION
023		
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

UNDER REVIEW
11/10/11

DEO ATTACHED
RELEASED
08-09-03 W

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AS	PORT HADLOCK, WA	
CHECKED	h	DRAWING NO.	REV. H
MFG. APPR.	h	D3391	SHEET 6 OF 8
APPROVED	h	TITLE	SCALE
DE APPR.	h	412 FLOAT SKIDTUBE	NTS
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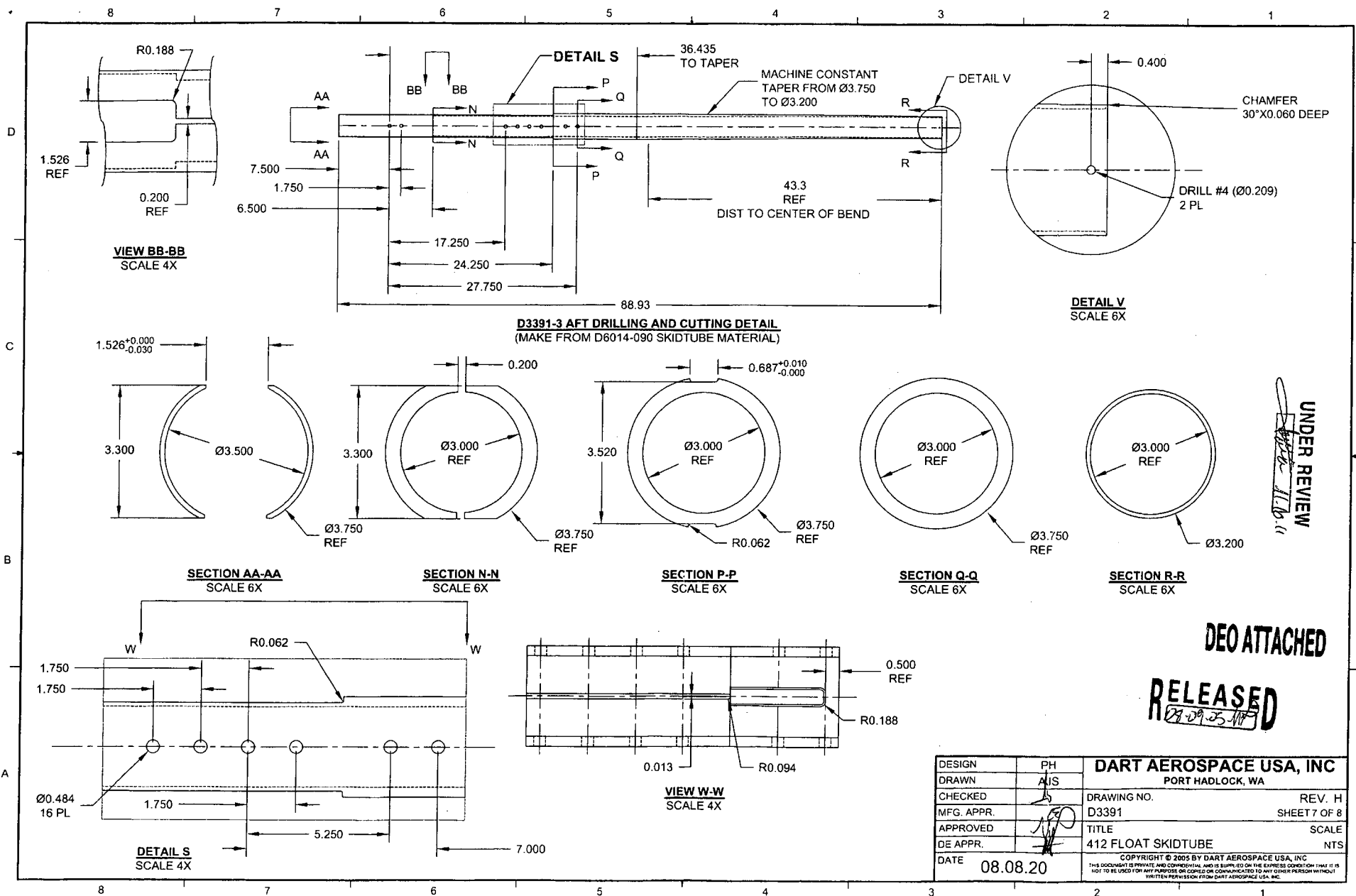
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



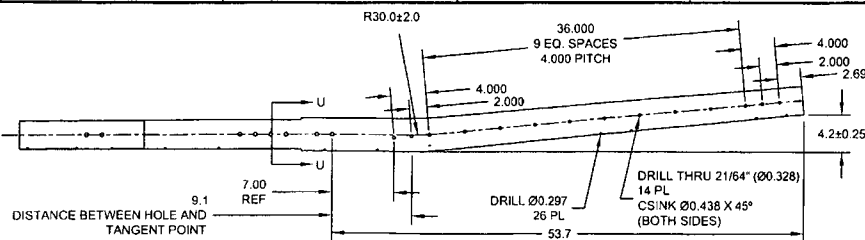
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

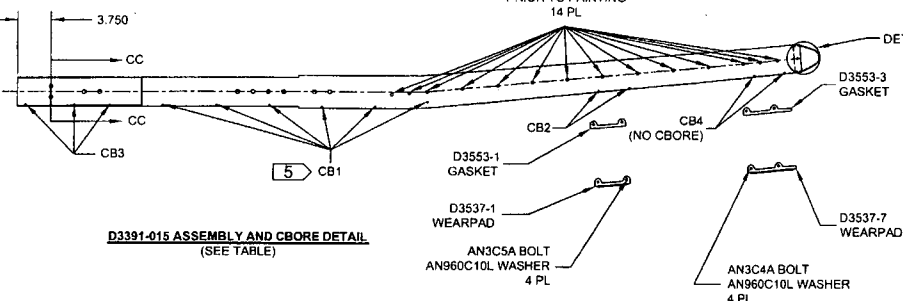
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3391-015 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)

INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6398
GRIND FLUSH
PRIOR TO PAINTING
14 PL



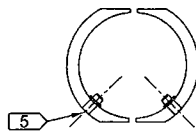
D3391-015 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

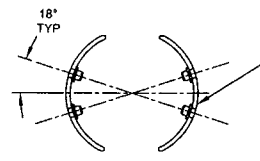
QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2846	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4	4	ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER

CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

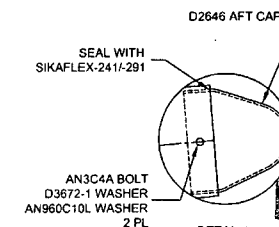


SECTION U-U
SCALE 3X



SECTION CC-CC
SCALE 3X

DRILL Ø0.391
CBORE Ø0.516 X 0.040 DEEP
INSTALL ALS4-428-165 INSERT
4 PL



DETAIL T
SCALE 4X

D3391-025 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)

SEAL WITH
SIKAFLEX-2411-291
AN3C4A BOLT
D3672-1 WASHER
AN960C10L WASHER
2 PL



DETAIL T
SCALE 4X

UNDER REVIEW
DEO ATTACHED
RELEASED
08-09-05

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>h</i>	MFG. APPR. <i>AA</i>	APPROVED <i>MP</i>		DE APPR. <i>MP</i>		
DATE 09.09.23	DATE 04.04.24	DATE 09/09/25	DATE 09/09/30		DATE 09/09/30		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02
MP

UNDER REVIEW

[Signature] 11.10.11
 PER PAR 11-125

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-742 REV. D
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-742 REV. 3

REF. CANADIAN STC: SH05-37
REF. FAA STC: SR01583SE
REF. EASA STC: EASA.IM.R.S.01126

PURPOSE:

The purpose of this service instruction is to introduce an alternate wearplate installation for the D412-742-011/-013 Skidtube Installations. The new DSI-9517-011 Wearplate Kit consists of new wearplates destined to replace existing D3564-1/-3 Wearshoes and D3566-1/-3 Gaskets. The components in the DSI-9517-011 Wearplate Kit are as defined in the parts list on sheet 4 of this service instruction.

INSTALLATION PROCEDURE:

Replace D3564-1/-3 Wearshoes and D3566-1/-3 Gaskets with D4095-041/-043 Wearplates Assemblies as follows:

1. Remove existing D3564-1/-3 Wearshoes and D3566-1/-3 Gaskets per Item 32.6.1 of ICA-D412-742. It might be necessary to loosen the aft end of D3564-5 Wearshoe and D3566-5 Gasket.
2. Remove qty.(4) AN4C52A Bolts, D3403-1 Bushings, and qty.(8) D3672-11 Washers as indicated in Figures 1 and 2 of this service instruction.
3. Inspect the skidtube and saddles per Chapter 5 of ICA-D412-742.
4. Seal existing inserts located on both sides of the skidtube in area shown in Figures 1 and 2 of this service instruction using Sikaflex -241/-291 or Proseal 890 or MIL-S-8802 Class 2B sealant.
5. Locate the DSI-9517-011 Wearplate Kit as shown in Figure 1 and 2 of this service instruction.
6. Transfer drill qty.(2) Ø0.438 hole from the skidtube/saddle to the D4095-041/-043 Wearplates Assemblies. Deburr. Touch up finish per Item 5.2.14 of ICA-D412-742 as required.
7. Install the DSI-9517-011 Wearplate Kit using the same AN3C hardware as shown in ICA-D412-742. Torque to 15-25 in-lbs (1.7-2.8 N-m).
8. Install D3403-5 Bushings and AN4C53A Bolts in lieu of D3403-1 Bushings and AN4C52A Bolts removed at step 2 above. Ensure that the nuts on the AN4C Bolts are on the inboard side of the skidtube. Torque to 50-70 in-lbs (5.7-7.9 N-m).
9. Amend weight and balance per the Weight and Balance Table below.

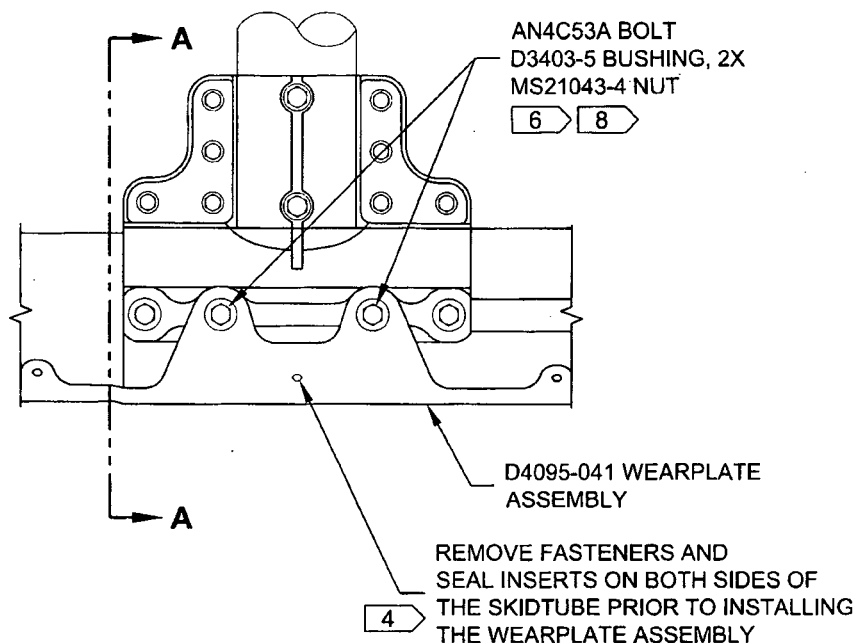
WEIGHT AND BALANCE:

Use the following weight and balance information for DART D412-742-011/-013 skidtube and saddle installations equipped with DSI-9517-011 Wearplate Kit.

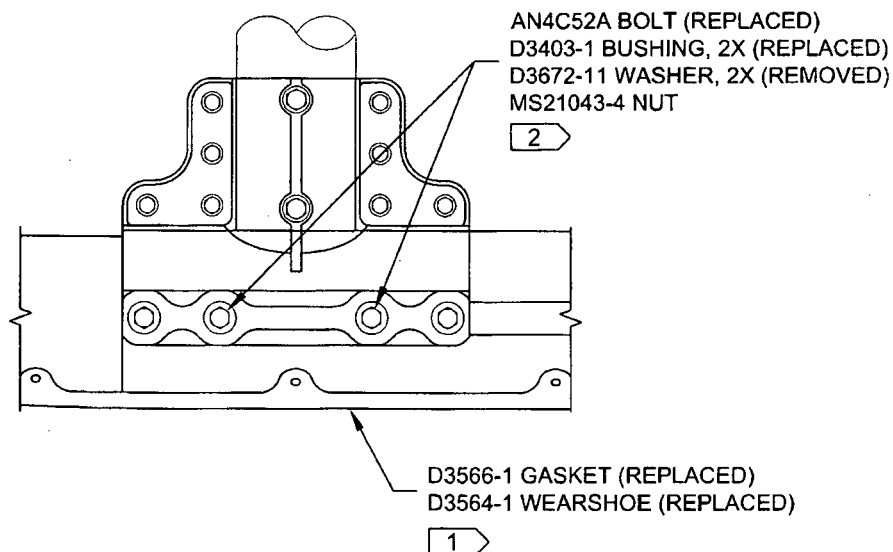
INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL	
		ARM	MOMENT	ARM	MOMENT
D412-742-011 <i>Float Skidtube Installation with DSI-9517-011 Kit Installed</i>	70.0 lb 31.8 kg	±55.0 in ±1.40 m	±3850 in-lb ±44.5 m-kg	130 in 3.3 m	9100 in-lb 105 m-kg
D412-742-013 <i>Float Skidtube Installation with DSI-9517-011 Kit Installed</i>	70.0 lb 31.8 kg	±55.0 in ±1.40 m	±3850 in-lb ±44.5 m-kg	130 in 3.3 m	9100 in-lb 105 m-kg

B	ITEM 21B AND 22B REMOVED FROM PARTS LIST		XDF	11.10.11
A	NEW ISSUE		MB	10.04.21
REV.	DESCRIPTION		BY	DATE
DESIGN			DART AEROSPACE USA, INC KENT, WA	
DRAWN				
CHECKED			DRAWING NO. REV. B	
MFG. APPR.	N/A		DSI 9517 SHEET 1 OF 6	
APPROVED			TITLE SCALE	
DE APPR.			ALTERNATE WEARPLATE KIT NTS	
DATE	11.10.11		COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

IS:



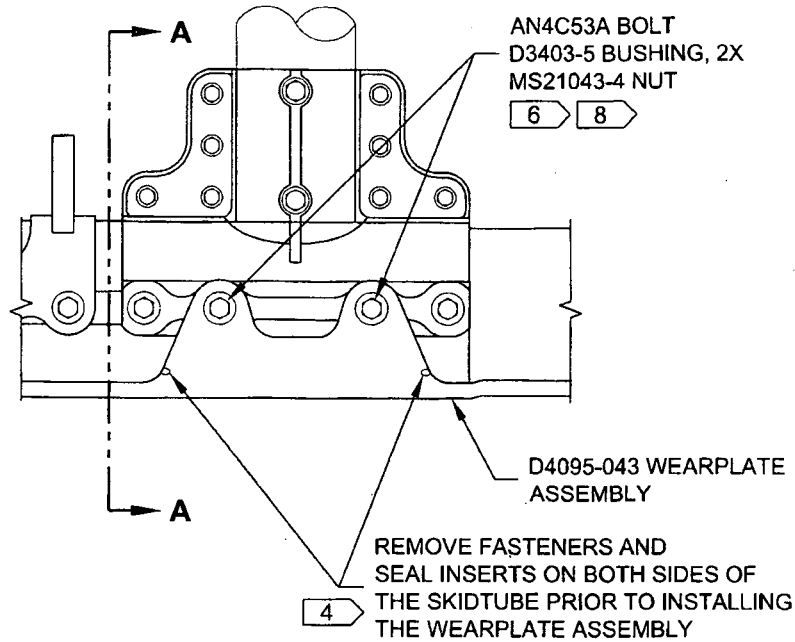
WAS:



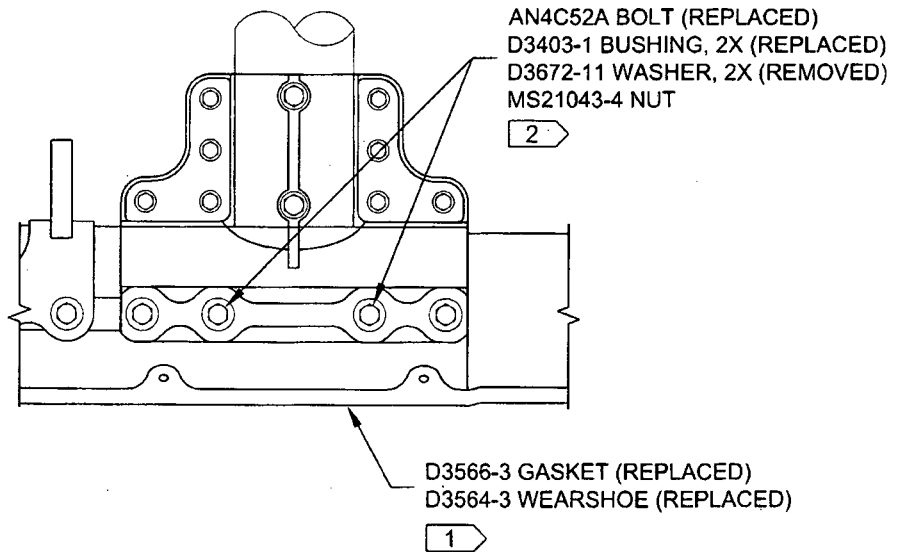
**FIGURE 1: CHANGE AT FORWARD SADDLE LOCATION
WITH DSI-9517-011 KIT INSTALLED**

DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9517	SHEET 2 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ALTERNATE WEARPLATE KIT	NTS
DATE	11.10.11	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

IS:

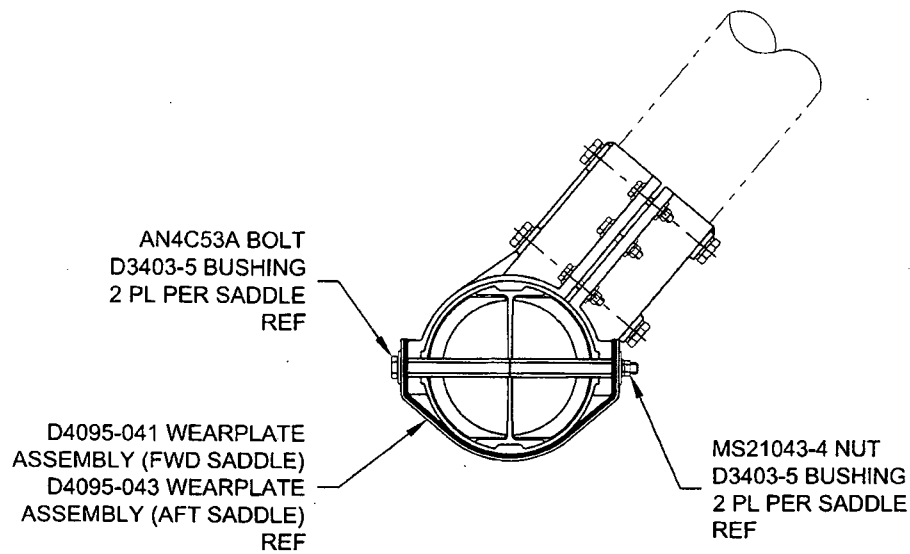


WAS:



**FIGURE 2: CHANGE AT AFT SADDLE LOCATION
WITH DSI-9517-011 KIT INSTALLED**

DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9517	SHEET 3 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ALTERNATE WEARPLATE KIT	NTS
DATE	11.10.11	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



SECTION A-A

DSI-9517-011 PARTS LIST:

QTY -011	PART NUMBER	DESCRIPTION
X	DSI-9517-011	WEARPLATE KIT
8	D3403-5	BUSHING
1	D4095-041	WEARPLATE ASSEMBLY
1	D4095-043	WEARPLATE ASSEMBLY
4	AN4C53A	BOLT

DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9517	SHEET 4 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ALTERNATE WEARPLATE KIT	NTS
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THE PARTS LISTS IN SECTION 32.15 OF ICA-D412-742 (PAGES 53 AND 55) AND SECTION 5.1 OF IIN-D412-742 (PAGES 16 AND 17) ARE AMENDED AS FOLLOWS WHEN OPTIONAL DSI-9517-011 KIT IS INSTALLED:

32.15 D412-742-011 (PMA/OEM) FLOAT SKIDTUBE INSTALLATION PARTS LIST (ICA-D412-742)
5.1 D412-742-011 (PMA/OEM) FLOAT SKIDTUBE INSTALLATION PARTS LIST (IIN-D412-742)

Item	QTY -011	QTY -041	QTY -015	PART NUMBER	DESCRIPTION
	X			D412-742-011	FLOAT SKIDTUBE INSTALLATION
	1	X		D412-742-041	FLOAT SKIDTUBE
	1		X	D412-742-015	ELECTRIC STEP KIT

IS:

3		10		AN3C6A	BOLT (REMOVED QTY.2)
4		4		AN3C7A	BOLT (REMOVED QTY.4)
5		38		AN960C10L	WASHER (REMOVED QTY.6)
21A		1		D4095-041	WEARPLATE ASSEMBLY
22A		1		D4095-043	WEARPLATE ASSEMBLY
46	8			D3403-1	BUSHING (REPLACED QTY.4 WITH D3403-5)
46A	8			D3403-5	BUSHING (REPLACES QTY.4 D3403-1)
49	4			AN4C52A	BOLT (REPLACED QTY.4 WITH AN4C53A)
49A	4			AN4C53A	BOLT (REPLACES QTY.4 AN4C52A)
53	8			D3672-11	WASHER (REMOVED QTY.8)

WAS:

3		12		AN3C6A	BOLT
4		8		AN3C7A	BOLT
5		44		AN960C10L	WASHER
21A		1		D3564-1	WEARPLATE
21B		1		D3564-3	WEARPLATE
22A		1		D3566-1	GASKET
22B		1		D3566-3	GASKET
46	16			D3403-1	BUSHING
49	8			AN4C52A	BOLT
53	16			D3672-11	WASHER

DESIGN	J	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	J	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9517	SHEET 5 OF 6
APPROVED	140	TITLE	SCALE
DE APPR.	H	ALTERNATE WEARPLATE KIT	NTS
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THE PARTS LISTS IN SECTION 32.16 OF ICA-D412-742 (PAGES 57 AND 59) AND SECTION 5.2 OF IIN-D412-742 (PAGES 18 AND 19) ARE AMENDED AS FOLLOWS WHEN OPTIONAL DSI-9517-011 KIT IS INSTALLED:

32.16 D412-742-013 (APICAL TRI-BAG) FLOAT SKIDTUBE INSTALLATION PARTS LIST (ICA-D412-742)
5.2 D412-742-013 (APICAL TRI-BAG) FLOAT SKIDTUBE INSTALLATION PARTS LIST (IIN-D412-742)

Item	QTY -013	QTY -043	PART NUMBER	DESCRIPTION
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-043	FLOAT SKIDTUBE

IS:

3		10	AN3C6A	BOLT (REMOVED QTY.2)
4		4	AN3C7A	BOLT (REMOVED QTY.4)
5		38	AN960C10L	WASHER (REMOVED QTY.6)
21A	1		D4095-041	WEARPLATE ASSEMBLY
22A	1		D4095-043	WEARPLATE ASSEMBLY
46	8		D3403-1	BUSHING (REPLACED QTY.4 WITH D3403-5)
46A	8		D3403-5	BUSHING (REPLACES QTY.4 D3403-1)
49	4		AN4C52A	BOLT (REPLACED QTY.4 WITH AN4C53A)
49A	4		AN4C53A	BOLT (REPLACES QTY.4 AN4C52A)
53	8		D3672-11	WASHER (REMOVED QTY.8)

WAS:

3		12	AN3C6A	BOLT
4		8	AN3C7A	BOLT
5		44	AN960C10L	WASHER
21A		1	D3564-1	WEARPLATE
21B		1	D3564-3	WEARPLATE
22A		1	D3566-1	GASKET
22B		1	D3566-3	GASKET
46	16		D3403-1	BUSHING
49	8		AN4C52A	BOLT
53	16		D3672-11	WASHER

DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9517	SHEET 6 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ALTERNATE WEARPLATE KIT	NTS
DATE	11.10.11	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

Linda Lacelle

From: Chris Provencal <cprovencal@dartaero.com>
Sent: November-08-11 11:32 AM
To: 'L Lacelle'
Cc: Mike Petsche; Xavier Faria; David Shepherd; Johnston, Kim
Subject: D412-742-xx w/os

FYI:

I will update all w/o's made with the new D3391 dwg to D412-742-013 CHG 007 and D412-742-043 CHG 005. Parts made to the old D3391 dwg will remain at CHG 006 and 004 respectively, but will have the DSI kit pre-installed. The w/o's for the old tubes will need to be re-worked per DSI 9517 Rev. B, with holes being plugged with sikaflex and such.

I've put the bluefile under review. There will be a new DSI 9517 Rev. B that will incorporate CHG # information., which the current DSI is lacking. When the document is ready, we'll do a new ECN to ensure all the CHG #'s get updated for all the paperwork.

-Chris

Chris Provencal

From: David Shepherd <dshepherd@dartaero.com>
Sent: Friday, November 18, 2011 3:21 PM
To: 'Chris Provencal'
Cc: 'Mike Petsche'; 'L Lacelle'
Subject: RE: Frankentribeams

I agree that these should be shipped as CHG 007.

David

From: Chris Provencal [<mailto:cprovencal@dartaero.com>]
Sent: November-18-11 12:17 PM
To: David Shepherd
Cc: Mike Petsche; 'L Lacelle'
Subject: Frankentribeams

David,

RE: D412-742-013

We were planning on sending two tri-beams at the old change number with the DSI wearplate kit installed. The customer wants all new wearplates. Additionally, one of the aft tubes was scrapped due to excessive machining marks on the ID, so it is replaced with a new-style tube.

This basically means we'd be shipping CHG 006 tubes, with CHG 007 wearplates, and one CHG 007 aft tube on one of the tubes. This isn't really covered by the DSI. I think that these should be shipped as CHG 007 (since from a customer standpoint, they are more functionally a CHG 007) with a deviation that the tubes have additional holes filled per the DSI. Is this acceptable?

-Chris

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries